

Date: Monday, 10/16/2006 2:02:47 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PROP ARM ASSEMBLY
Job Number	: 29023		
Estimate Number	: 10730		
P.O. Number	: <i>N/A</i>	Part Number	: D2982041
This Issue	: 10/16/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2982 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 27507	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/10/2006 Qty: 15 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: EST rev A 00.06.05 New Issue EC		
	: EST rev B 06.05.05 ECN 797 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Clevis

Pick:

Qty	Part number	Description	Batch
1	D2012-107	Clevis	<i>B27522</i> X15

ml

2.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Spacer

Pick:

Qty	Part number	Description	Batch
2	D2022-101	Spacer	<i>B26327</i> X30

ml

3.0	D2429041	Spring Clip Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Spring Clip Ass'y

Pick:

Qty	Part number	Description	Batch
1	D2429-041	Spring clip ass'y	<i>B29025</i> X15

ml

4.0	D2588	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Bracket

Pick:

Qty	Part number	Description	Batch
2	D2588	Mounting channel	<i>B 24637</i> X30

ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:02:47 PM
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Drawing Name: PROP ARM ASSEMBLY

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2730

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Door Prop

Pick:

Qty Part number

Description

Batch

1

D2730

Prop arm

B29491 x B4
B27527 x 9
B24638 x 2

ml

6.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick:

Qty

Part number

Description

Batch

1

AN4-10A

Bolt

M101291 x 3
B17073 x 12

ml

7.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick:

Qty

Part number

Description

Batch

1

AN4-4A

Bolt

M19471 x 3
M100857 x 12

ml

8.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty

Part number

Description

Batch

2

AN960JD416

Washer

M101938 x 30

ml

9.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Rivet, Universal Head

Pick:

Qty

Part number

Description

Batch

2

MS20470AD4-5 Rivet

M102455 x 30

ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:02:47 PM
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Drawing Name: PROP ARM ASSEMBLY

Job Number: 29023

Part Number: D2982041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 30.0000 Each(s)

Nut

Pick:

Qty

Part number

Description

Batch

2

MS21042L4

Nut

M 19185

x30

ml

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(X15)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2982

ml 07/01/15

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/15 (15)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51121*

CB 04/01/16 (15)

07/01/16

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/17

Job Completion



CL 07/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

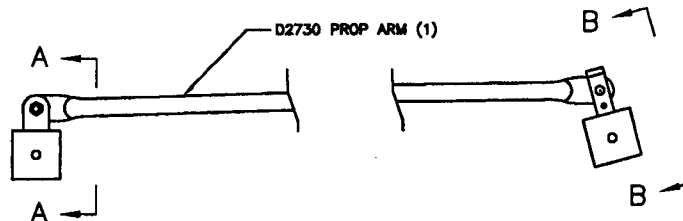
DESIGN RF	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED J J	APPROVED H	DRAWING NO. D2982	REV. B SHEET 1 OF 1
DATE 06.04.06		TITLE PROP ARM ASSEMBLY	SCALE NTS
A	00.06.05	NEW ISSUE	
B	06.04.06	MS20470AD4-5 WAS MS20470AD4-6	

RELEASED

06-04-11 H

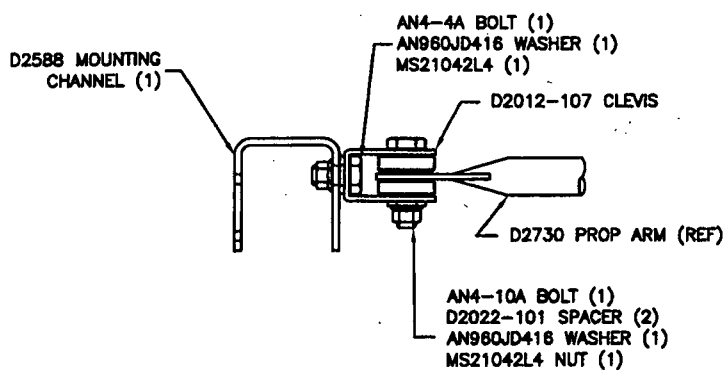
Qty -041	Part Number	Description
X	D2982-041	PROP ARM ASSEMBLY
1	D2012-107	CLEVIS
2	D2022-101	SPACER
1	D2429-041	SPRING CLIP ASSEMBLY
2	D2588	MOUNTING CHANNEL
1	D2730	PROP ARM
1	AN4-10A	BOLT
1	AN4-4A	BOLT
2	AN960JD416	WASHER
2	MS20470AD4-5	RIVET
2	MS21042L4	NUT (OR MS21042-4)

B

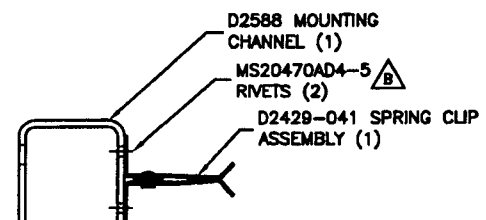


D2982-041 PROP ARM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29023



SECTION A-A



SECTION B-B

(PROP ARM REMOVED FOR CLARITY)

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